

Work Order ID 128979

128979

Page 1

Tuesday, January 27, 2015 7:55:53 AM

Item ID: D3996-FE-832-EF Accept *N900040100* Setup Start *NS1*
 Revision ID: 500 500 CL 5/02/02 Stop *NS2*
 Item Name: Self-Clinching Fastener
 Start Date: 1/26/15 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 100.00 *100* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1501-29 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3996	A								

100 0.00
 100
 Purchasing
 Purchasing
 Memo
 Issue P/O: 27296
 Purchase Part Number: FE-832-EF
 Supplier: Interfast Inc.
 Certificate of conformity is required
 0.00
 CL 15/02/02 500

110 0.00
 110
 Packaging
 Packaging
 Memo
 0.00
 500X SP 15-02-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Item ID: D3996-FE-832-EF

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Self-Clinching Fastener

Stop ***NS2***

Start Date: 1/26/15 Start Qty: 100.00

100

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

FEB 10 2015

500X SP15-02-11

MCT 15-02-17

MS-212

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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D3996-FF-832-FF

Start Date: 1/26/15**Required Date:** 1/26/15

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP RevA: new issue 09.11.11 DD verified by:EC

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

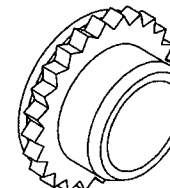
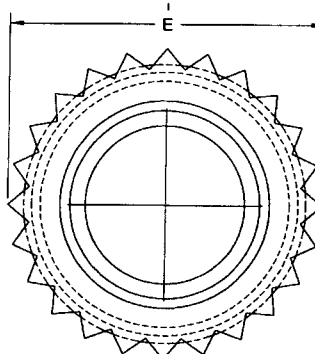
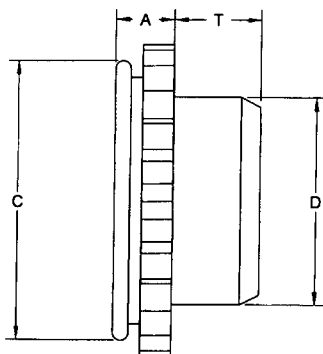
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SPECIFICATION CONTROL DRAWING



D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C ± 0.009 -0.005	D MAX	E ± 0.005	T ± 0.015 -0.000	HOLE SIZE IN SHEET ± 0.003 -0.000	MIN DIST: HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FEO	0.040	0.039-0.045	0.171	0.145	0.192	0.065	0.172	0.14	0.00031
		FE	0.060	0.059-0.070							0.00037
#6-32 (0.138)	632	FEO	0.040	0.039-0.045	0.212	0.180	0.244	0.075	0.213	0.17	0.00047
		FE	0.060	0.059-0.070							0.00068
#8-32 (0.164)	832	FEO	0.040	0.039-0.045	0.289	0.215	0.322	0.090	0.290	0.20	0.00098
		FE	0.060	0.059-0.070							0.00124
#10-32 (0.190)	032	FEO	0.040	0.039-0.045	0.289	0.245	0.322	0.110	0.290	0.20	0.00104
		FE	0.060	0.059-0.070							0.00120
1/4-28	0428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

NOTES

1) SPECIFICATION: PENNENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING
PEM P/N XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FEO" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE
"YYY" = THREAD CODE PER TABLE
"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:
DART P/N = D3996-FE-832-EF
PEM P/N = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:

"C" = CADMIUM YELLOW CHROMATE PER ASTM B766 CLASS 5 TYPE II
"CI" = CADMIUM CLEAR CHROMATE PER ASTM B766 CLASS 5, TYPE III
"EF" = ELECTRO-FILM PER MIL-PRF-46010
"MD" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED
2009-11-08

A	NEW ISSUE	CP	09.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3996** REV. A
SHEET 1 OF 1

TITLE **SELF-CLINCHING FASTENER** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27296

Purchase Order Date 2/2/2015

PO Print Date 2/2/2015

Page Number 1 of 2

Order From :

VU-WES002

Ship To : DART AEROSPACE LTD

WESCO AIRCRAFT HARDWARE CORP
PO BOX 802020
SANTA CLARITA, CA 91380-2020
USA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 661-775-7200

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	50-009-2	Grommet	2/4/2015 Yes 2/4/2015		50.00 Each	\$0.30	\$15.00
Line Total:							\$15.00
2	AN45-13A	EYE BOLT	2/4/2015 Yes 2/4/2015		8.00 Each	\$23.50	\$188.00
Line Total:							\$188.00
3	FE-832-EF	PEM Insert	2/13/2015 Yes 2/13/2015		500.00 Each	\$0.35	\$175.00

AS PER DWG D3996 REV. A
B128979

PO Instructions: Fedex Acc#151793240

Note:

2/2/2015

**Wesco Aircraft®****Wesco Aircraft Canada Inc.**

Pack Slip

Pack Slip #



Customer PO #

2800 Matheson Blvd. East; Mississauga, ON L4W 4X5
PH: 289/3745500 FAX: 289/3745501

Sales Order #



Pack Slip #	Date	Page #
8502479	2/6/2015 10:59:45	1 of 1
Customer PO #		
PO27296		
Sales Order #	Ordered By	
9025072 SO	CHANTAL	
Payment Terms		
030 Net 30		
Salesperson	Related Order #	
Hudson, Samantha		
TOTE ID:	7014	

Bill To: 2440829 (IF110900_
 DART AEROSPACE LIMITED
 1270 ABERDEEN ST.
 HAWKESBURY ON K6A 1K7
 Canada

Ship To: 2440829 (IF110900_
 DART AEROSPACE LIMITED
 1270 ABERDEEN ST.
 HAWKESBURY ON K6A 1K7
 Canada
Ship Inst: COL IF110900_BILLA00**Carrier:** Fed Ex Priority Overnight

Item #	Quantities			Part Number / Description	Certifications	Promise Date
	Shipped	Backorder	U/M			

3	500	0	EA	FE-832-MD	Cert-Mfr's C of C	2/4/2015
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NUT

Lot # Manufacturer's Lot #:

31135238 512397

Manufacturer Name

PENN ENGINEERING & MFG. CORP.

Lot Qty

500



Export Classification. EAR 99

Country Of Origin: US

Comments: FREIGHT ACCOUNT NUMBER: 151793240**Export Statement**

SP15-02-10

Certificate of Conformance GST/HST #: 81989 5574 RT0001 QST #: 12 2184 4579 TQ 0001 **Total Weight** **Total # Boxes**

Wesco Aircraft certifies that all products are of new manufacture. Documentation from the manufacturer certifies that the product meets all applicable Government, Customer and/or Manufacturer's specifications and requirements. Wesco certifies that the whole of the supplies detailed hereon have been received under cover of the Release Certificate quoted above and are in the same condition when received. This documentation is maintained on file permanently and available upon request.

I hereby certify that the Aircraft Parts, Appliances and or materials described hereon were acquired from a source of supply that is consistent with the conditions under which the department of Transport Distributor approval No. 178-94 has been granted certified by:

Signed:

Quality Assurance Manager

We hereby certify that no returns will be accepted without WESCO Returned Material Authorization number. Only lot traceable material will be accepted for return.

Wesco's standard terms and conditions can be found at https://www.wescoair.com/eng/company/Downloads/Wesco_Aircraft_Terms_and_Conditions_of_Sale.pdf and, except as explicitly agreed by Wesco and the buyer in a writing signed by both parties, shall be applicable to, and deemed incorporated into this order. These terms and conditions shall govern the order notwithstanding any term and conditions that were included in the order by the buyer. Acceptance of the order shall be deemed an acceptance of these terms and conditions and, except as expressly agreed by Wesco and the buyer in a writing signed by both parties, these terms and conditions shall supersede, nullify and void any other terms, conditions, representations, understandings, in oral or written form.

**Penn Engineering & Manufacturing Corp.
Winston-Salem, NC, U.S.A.**

Certificate of Compliance

Subject to the provisions in our standard Terms and Conditions of Sale, we hereby confirm that with respect to the products supplied in this order, that (i) in the case of products ordered from our catalog, the products substantially conform to the description set out in our current catalog at the time we accepted your order, and (ii) in the case of products based on your drawings or specifications, the products substantially conform to your drawings and specifications, if and to the extent that we previously agreed in writing to each applicable drawing and/or specification.

Mike Burgarner
Mike Burgarner
Quality – Shipping Manager



PENN ENGINEERING & MANUFACTURING CORP.

CERTIFICATE OF COMPLIANCE

5190 OLD EASTON ROAD

DANBORO, PA

US 18916

Pl. No. FE-832 MD (Ref: _____)

Purchase Order No. 9025072

Lot Code 512397

Quantity 500

The PEM®/Standard Insert fastener is a proprietary product with specifications and performance characteristics as set forth in our published literature. This certificate asserts that the fasteners supplied under this order are in full compliance with these specifications and performance requirements. Quality information, including statistical control data, is on file at our manufacturing location to support this certification.

All of these records, techniques, and specifications are not necessarily in compliance with the complete terms of your order; however, the information contained on your specifications and drawings has been taken from our bulletin describing these fasteners, and to that end we certify that these fasteners will meet all specifications and requirements of that bulletin. Objective quality evidence substantiating this statement is on file at our facility.

We further certify that no mercury, mercury compounds, or polychlorinated biphenyls (PCB's) have been used in the manufacture or processing of this fastener.

PENN ENGINEERING & MANUFACTURING CORP.

ORIE V. KRISTEL III
QUALITY MANAGER